Facebook QR Code

KINGROON

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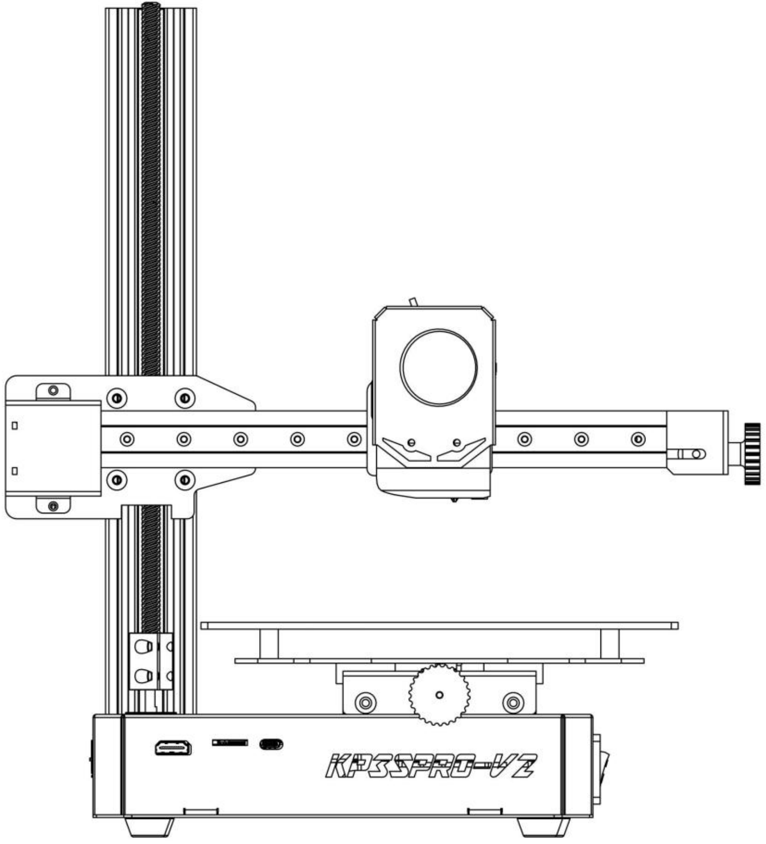
Facebook/YouTube: KingRoon 3D Printer

KINGROON

KP3S PRO V2-FDM 3D Printe

Instructions



catalog

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8. Software installation
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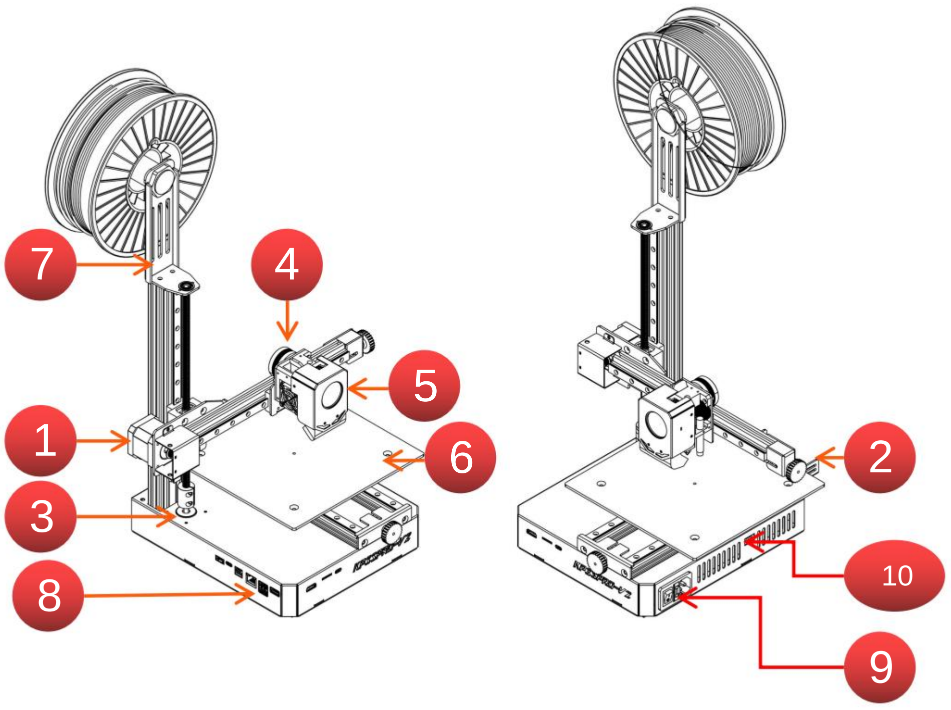
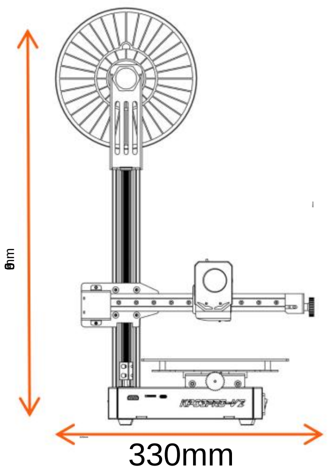
Notes:
Inordertousetheproductcorrectly,pleasereadthemanualcompletely

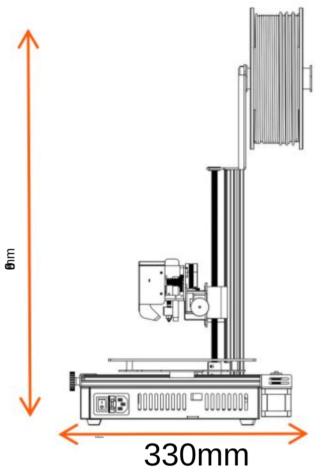
1.Product Description



1. X-axis motor	6. Hot bed
2. Y-axis motor	7. Material rack
3. Z-axis motor	8. Mainboard control interface
4. E-axis motor	9. Power switch/socket
5. Extruder	10. 110V/220V switching

1.Product Description

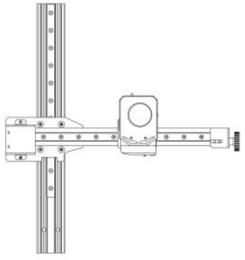


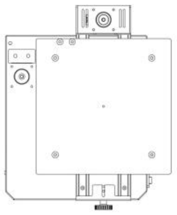


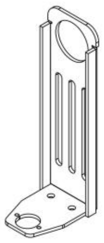
Model Number KP3S Pro V2	
Technology FDM	
Nozzle Quantity	1
Nozzle Diameter 0.4mm	
Print resolution	0.05-0.3mm
Filament Diameter 1.75mm	
Applicable Filament PLA/WOOD/TPU	
Max Nozzle Temp ÿ260 C	
Max Bed Temp ÿ100 C	
Max Axis Speed ÿ500mm/s	
Print Speed ÿ350mm/s	
Proposal Speed 200mm-350mm/s	
Print Via Web/TIF Card	
Compatible File Format	STL/Obj/Gcode

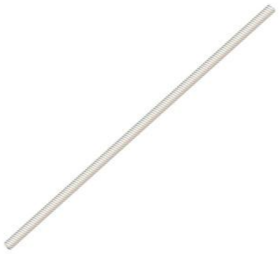
Compatible OS	Win7-10/Mac/Linux
Slicer	Cura/Slice/Host...
Language CN/EN	Klipper
Rated Power 200W	
Rated voltage 110V-220V	
Power supply 24V12.5A300W	
Filament Sensor Support extension	
Auto Leveling	yes
Resume Printing	No
Net Weight	6kg
Machine Size 330*330*590mm	
Build Volume 200*200*200mm	

2.Packing list


Assembly1


Assembly2

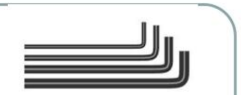

Holder


T8-Screw rod

USB flash disk

Power Cable

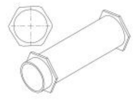
Pliers

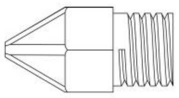

wrench
1.5mm 2.0mm 2.5mm 3.0mm

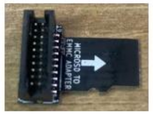
Adapter cable

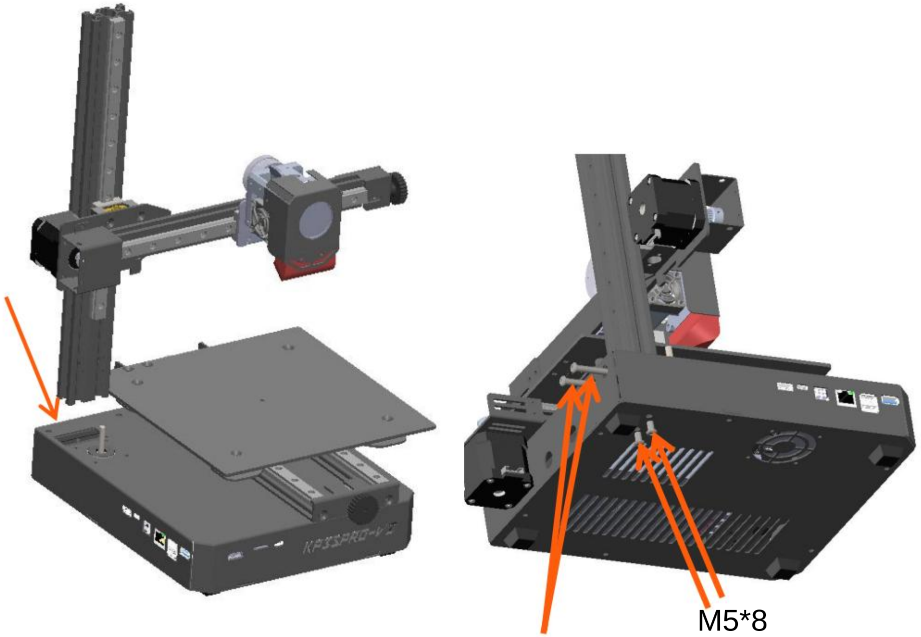
Network cable

M5*6-3PCS
M5*10-3PCS
M5*30-3PCS


Filament holder

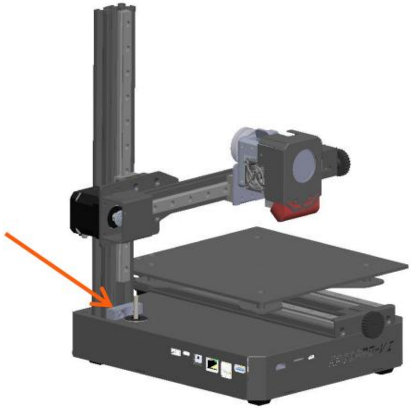

0.4mm Nozzle


EMMC Adapter



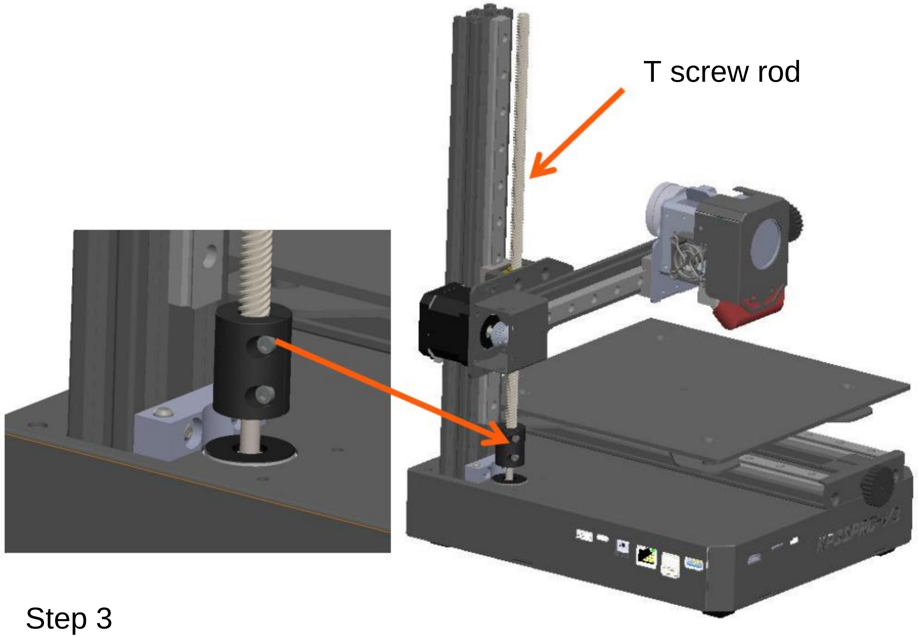
Step 1

Insert assembly 1 into assembly 2 to fix it. The bottom screw M5 * 30 and the rear screw M5 * 10 are used



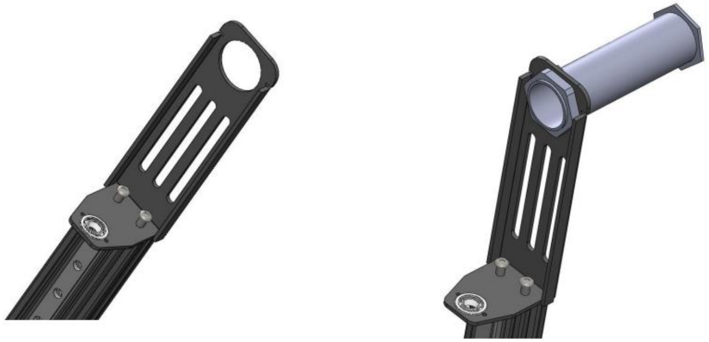
Step 2

Lock the Z-axis fixing block



Step 3

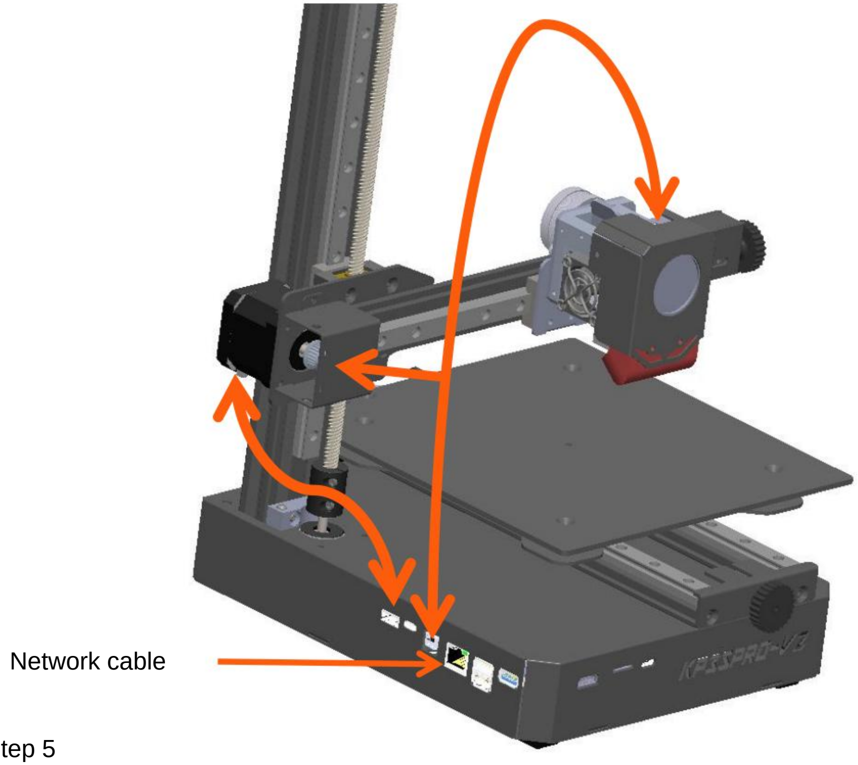
Insert the T-screw rod into the T-shaped nut, link and lock it with a coupling



Step 4

Fix the material rack onto the Z-axis 2040 aluminum profile with M5 * 6 screws, and connect the material pipe Fixed on the material rack

3.3.Assembly instructions



Step 5

1: Take out the X-axis motor cable to link the motor and main board 2. Take out the connecting extrusion head and main board of the adapter cable, and fix the adapter cable with a rolling strip On the X-axis motor cover

3: Plug in the network cable and your router link

Step 6

Plug in the power cord to power on

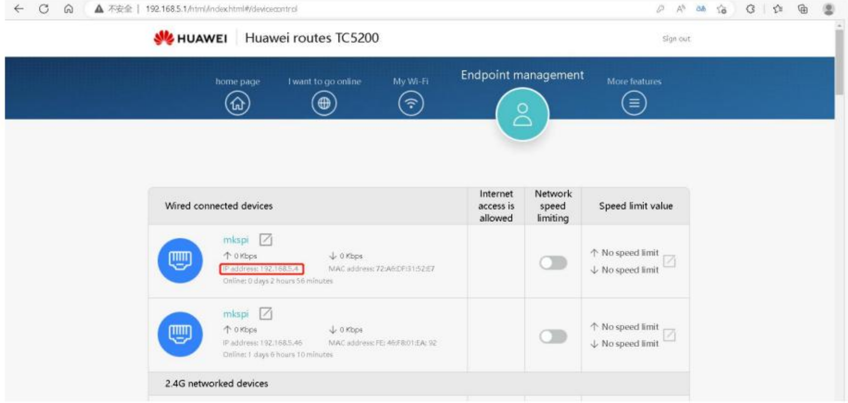
Please note: Please confirm the local voltage before starting the machine

Requirements, 110V/220V switching

4.KlipperUsing Tutorials

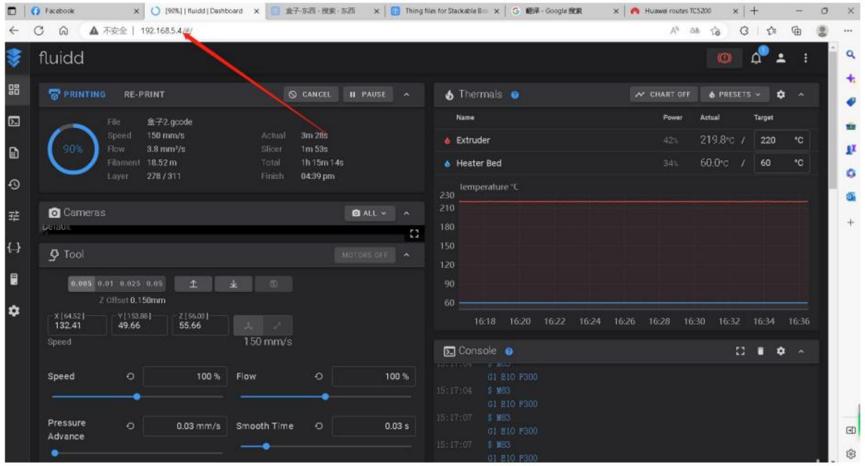
Step 1: Enter your router web page to view the device IP address, and ensure that the computer and printer Connect to the same router and log in to the router management terminal (login method:

Always check the device IP address on the back of the router



Wired connected devices	Internet access is allowed	Network speed limiting	Speed limit value
mkspi ↑ 0 Kbps ↓ 0 Kbps IP address: 192.168.5.4 MAC address: 72:A6:DF:31:52:E7 Online: 0 days 2 hours 56 minutes			↑ No speed limit ↓ No speed limit
mkspi ↑ 0 Kbps ↓ 0 Kbps IP address: 192.168.5.46 MAC address: FE: 46:F8:01:EA: 92 Online: 1 days 6 hours 10 minutes			↑ No speed limit ↓ No speed limit
2.4G networked devices			

Step 2: Create a new webpage and enter the queried IP address to enter the Fluidd operation The Fluidd operation interface currently only supports switching between Chinese and English



File 盒子2.gcode
Speed 150 mm/s
Flow 3.8 mm³/s
Filament 18.52 m
Layer 278 / 311
Actual 3m 28s
Slicer 1m 53s
Total 1h 15m 14s
Finish 04:39 pm

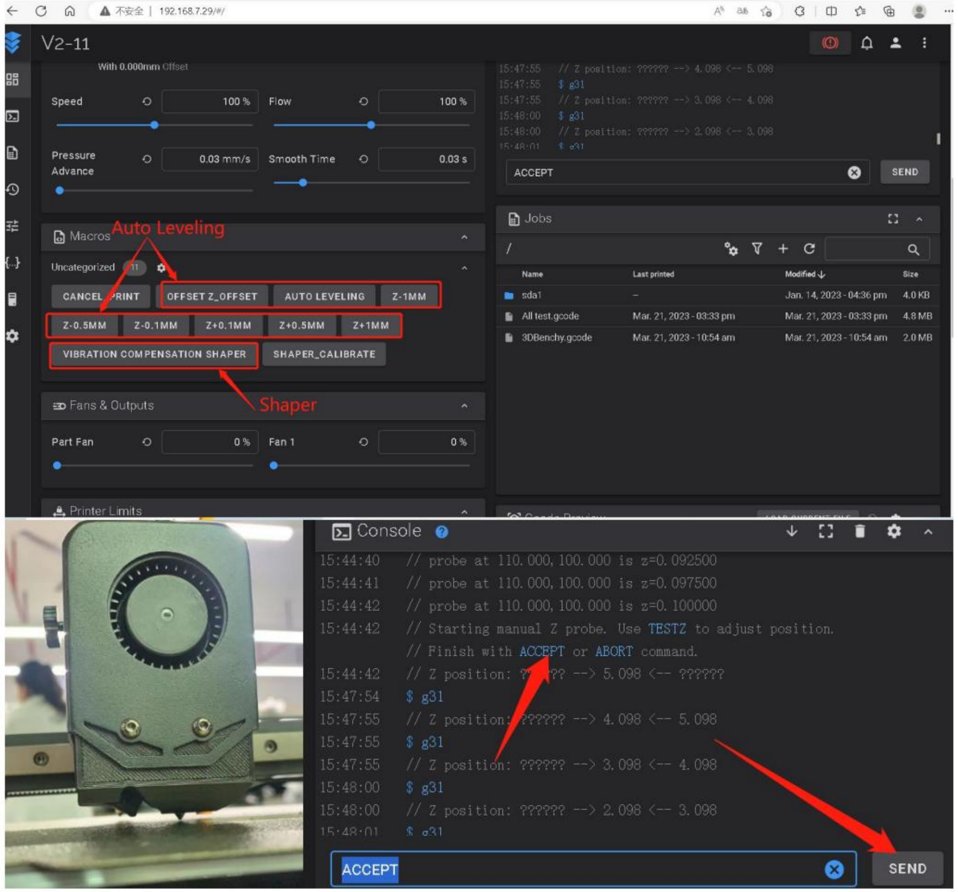
Extruder 219.8°C / 220 °C
Heater Bed 60.0°C / 60 °C

Z Offset 0.150mm
X [64.52] 132.41
Y [153.88] 49.66
Z [56.03] 55.66
150 mm/s
Speed 100 %
Flow 100 %
Pressure Advance 0.03 mm/s
Smooth Time 0.03 s

5.Auto leveling

Step 1: Drag down to the Macros option and click Offset z_ Offset button, the printer will move to the hot bedCenter position, click Z-1mm Z-0.5mm Z-0.1mm Z+0.1mm Z+0.5mm Adjust the distance between the nozzle and the hot bed by Z+1mm (0.1mm, approximately one A4 sheet of paper After adjustment, click the command bar ACCEPT to send it.

Step 2: Click Automatic Leveling to perform 16-point leveling. After leveling, Klipper will automatically restart and save the data.



Speed 100 %
Flow 100 %
Pressure Advance 0.03 mm/s
Smooth Time 0.03 s
Part Fan 0 %
Fan 1 0 %

Name	Last printed	Modified	Size
sda1	–	Jan. 14, 2023 - 04:36 pm	4.0 KB
All test.gcode	Mar. 21, 2023 - 03:33 pm	Mar. 21, 2023 - 03:33 pm	4.8 MB
3DBenchy.gcode	Mar. 21, 2023 - 10:54 am	Mar. 21, 2023 - 10:54 am	2.0 MB

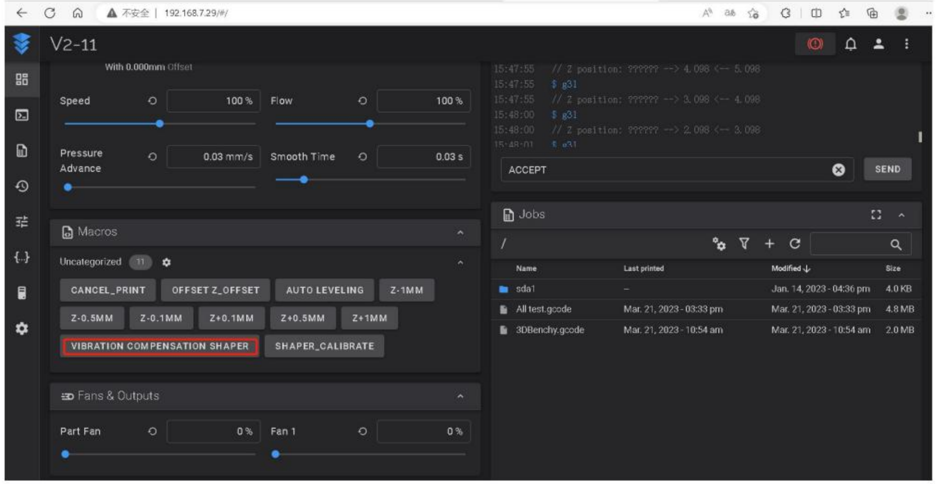
```
15:44:40   // probe at 110.000,100.000 is z=0.092500
15:44:41   // probe at 110.000,100.000 is z=0.097500
15:44:42   // probe at 110.000,100.000 is z=0.100000
15:44:42   // Starting manual Z probe. Use TESTZ to adjust position.
           // Finish with ACCEPT or ABORT command.
15:44:42   // Z position: ?????? --> 5.098 <-- ??????
15:47:54   $ g31
15:47:55   // Z position: ?????? --> 4.098 <-- 5.098
15:47:55   $ g31
15:47:55   // Z position: ?????? --> 3.098 <-- 4.098
15:48:00   $ g31
15:48:00   // Z position: ?????? --> 2.098 <-- 3.098
15:48:01   $ g31
```

ACCEPT

6.Input shaper

Step 1: Drag down to the Macros option, click the vibration compensation shaper, and wait for the vibration frequency data.

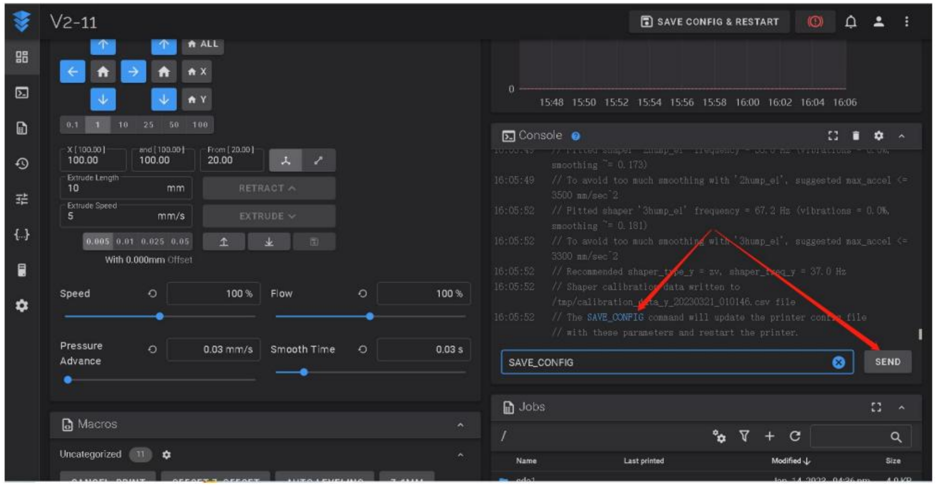
Note: During the vibration compensation process, the printer may generate vibration noise during the vibration compensation shaper.



```
15:47:55   // Z position: ?????? --> 4.098 <-- 5.098
15:47:55   $ g31
15:47:55   // Z position: ?????? --> 3.098 <-- 4.098
15:48:00   $ g31
15:48:00   // Z position: ?????? --> 2.098 <-- 3.098
15:48:01   $ g31
```

ACCEPT

Step 2: View the vibration data and click SAVE_ CONFIG, Klipper will automatically restart

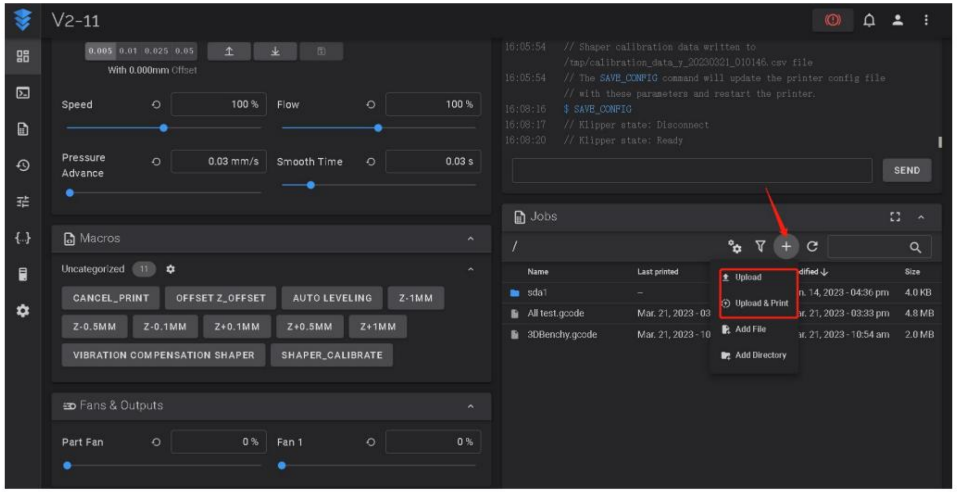


```
           smoothing ~= 0.173)
16:05:49   // To avoid too much smoothing with '2hump_ei', suggested max_accel <=
           3500 mm/sec^2
16:05:52   // Fitted shaper '3hump_ei' frequency = 67.2 Hz (vibrations = 0.0%,
           smoothing ~= 0.181)
16:05:52   // To avoid too much smoothing with '3hump_ei', suggested max_accel <=
           3300 mm/sec^2
16:05:52   // Recommended shaper_type_y = zv, shaper_freq_y = 37.0 Hz
16:05:52   // Shaper calibration data written to
           /tmp/calibration_data_y_20230321_010146.csv file
16:05:52   // The SAVE_CONFIG command will update the printer config file
           // with these parameters and restart the printer.
```

SAVE_CONFIG

7.How to Print

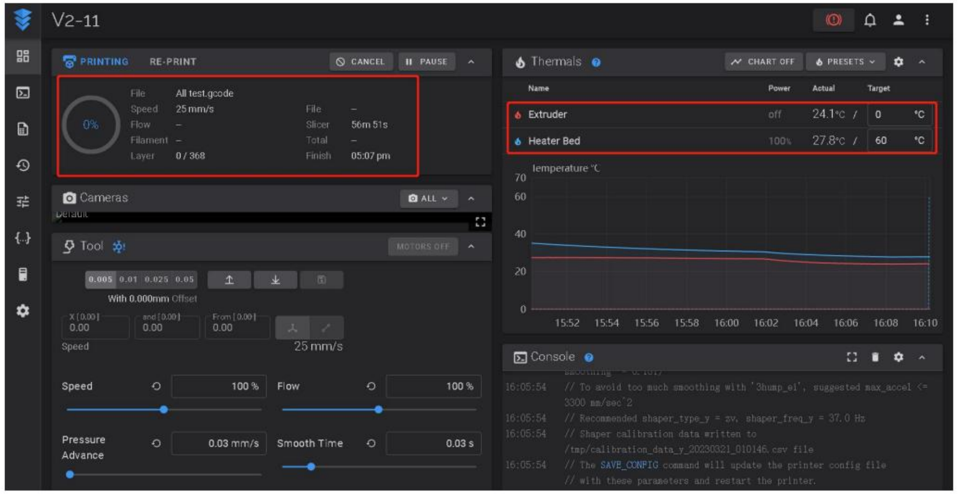
Step 1: Find the Jobs option and add Gcode for printing



```
16:05:54   // Shaper calibration data written to
           /tmp/calibration_data_y_20230321_010146.csv file
16:05:54   // The SAVE_CONFIG command will update the printer config file
           // with these parameters and restart the printer.
16:08:16   $ SAVE_CONFIG
16:08:17   // Klipper state: Disconnect
16:08:20   // Klipper state: Ready
```

Name	Last printed	…dified ↓	Size
sda1	–	…n. 14, 2023 - 04:36 pm	4.0 KB
All test.gcode	Mar. 21, 2023 - 03	…ar. 21, 2023 - 03:33 pm	4.8 MB
3DBenchy.gcode	Mar. 21, 2023 - 10	…ar. 21, 2023 - 10:54 am	2.0 MB

Step 2: Wait for the nozzle and hot bed to reach the predetermined temperature, and the printer will start printing



File: All test.gcode
Speed: 25 mm/s
Flow: –
Filament: –
Layer: 0 / 368
File: –
Slicer: 56m 51s
Total: –
Finish: 05:07 pm

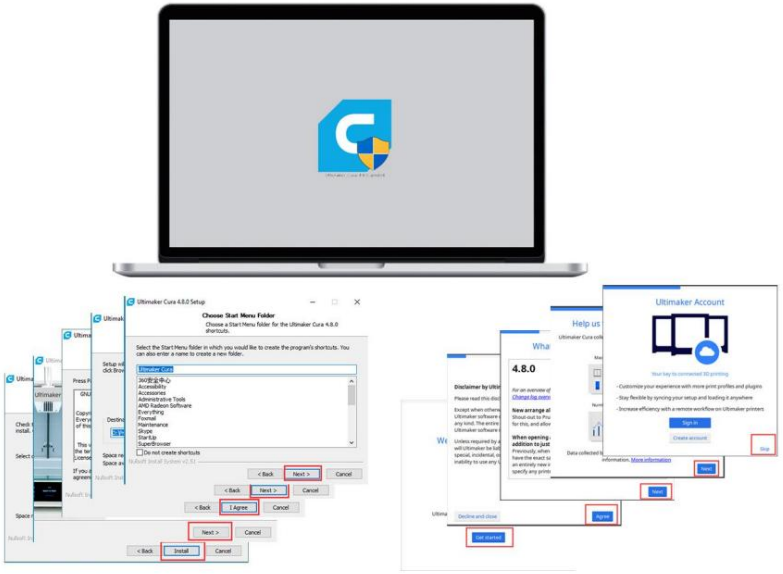
Name	Power	Actual	Target
Extruder	off	24.1°C /	0 °C
Heater Bed	100%	27.8°C /	60 °C

X [0.00] 0.00
and [0.00] 0.00
From [0.00] 0.00
Speed 25 mm/s
Speed 100 %
Flow 100 %
Pressure Advance 0.03 mm/s
Smooth Time 0.03 s

```
16:05:54   // To avoid too much smoothing with '3hump_ei', suggested max_accel <=
           3300 mm/sec^2
16:05:54   // Recommended shaper_type_y = zv, shaper_freq_y = 37.0 Hz
16:05:54   // Shaper calibration data written to
           /tmp/calibration_data_y_20230321_010146.csv file
16:05:54   // The SAVE_CONFIG command will update the printer config file
           // with these parameters and restart the printer.
```

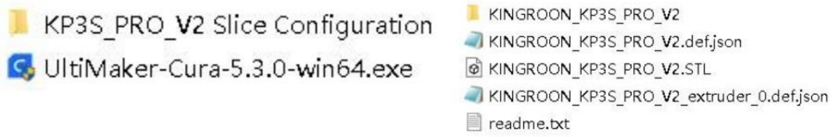
8.Software installation

Step 1: On the USB flash disk Find Cura Slicing Software on and install it on your computer (please remember the installation location)



Step 2: Open the configuration folder of KP3S Pro V2 and follow the installation instructions in the installation folder

Machine configuration, Cura needs to be restarted after configuration is completed



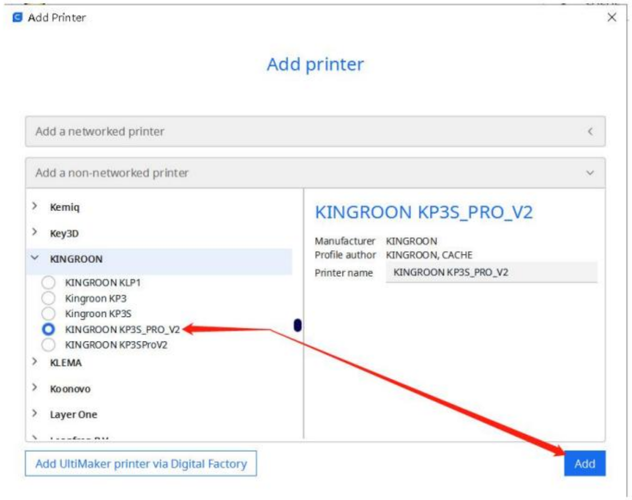
KP3S_PRO_V2 Slice Configuration
UltiMaker-Cura-5.3.0-win64.exe

KINGROON_KP3S_PRO_V2
KINGROON_KP3S_PRO_V2.def.json
KINGROON_KP3S_PRO_V2.STL
KINGROON_KP3S_PRO_V2_extruder_0.def.json
readme.txt

9.Software Settings

Step 2: Add your printer to Cura

Start Cura – Click on “Settings” – “Printer” – “Add Printer” – “Add a networked printer” – select “Kingroon” – “KP3S Pro V2” on the dropdown menu



Add Printer

Add printer

Add a networked printer

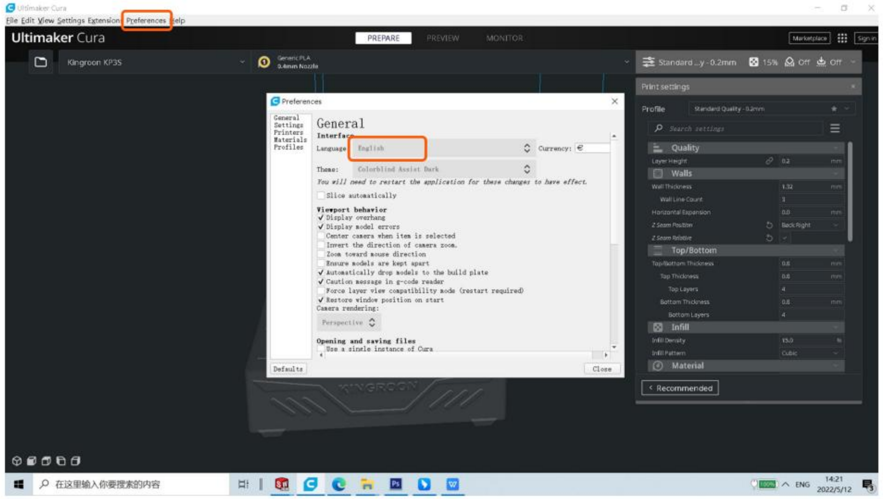
Add a non-networked printer

- Kemiq
- Key3D
- KINGROON
  - ○ KINGROON KLP1
  - ○ Kingroon KP3
  - ○ Kingroon KP3S
  - ● KINGROON KP3S_PRO_V2
  - ○ KINGROON KP3SProV2
- KLEMA
- Koonovo
- Layer One

KINGROON KP3S_PRO_V2

Manufacturer KINGROON
Profile author KINGROON, CACHE
Printer name KINGROON KP3S_PRO_V2

Select the language you want and restart Cura



General

Interface

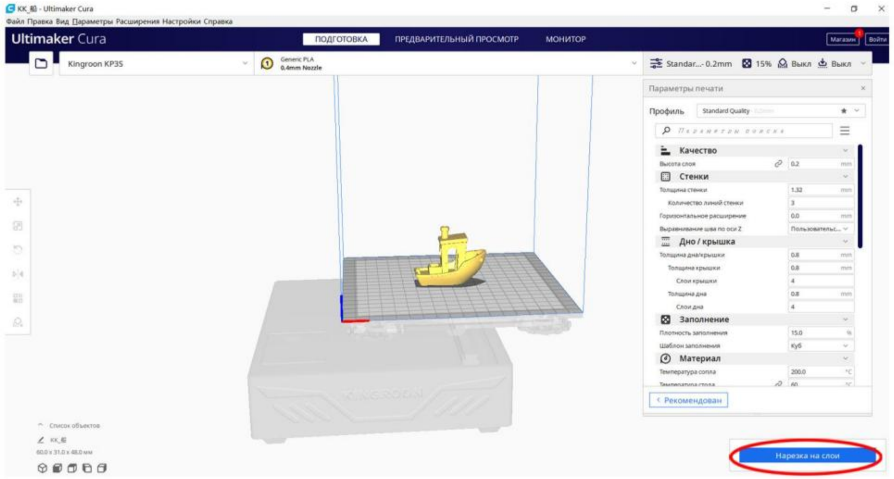
Language: English

Currency: €

Theme: Colorblind Assist Dark

You will need to restart the application for these changes to have effect.

9.Software Settings



Kingroov has configured all parameters,

You can directly save and add Gcode to Klipper for printing.

"If there are printing issues after changing settings,",

Please contact Jinlong Customer Service.

We will solve the problem for you as soon as possible,

You can also join Facebook discussion groups

10.matters attention

1. Do not operate the main board and adapter board while powered on

2. Non professional players are not allowed to arbitrarily change the configuration

11.Safety Instructions

Note:Each 3D printer has been tested before leaving the factory. If there is a little filament remaining in the nozzle or a slight scratch on the printing platform, it is normal and it will not affect the performance. Safe Working Environment The KINGROON 3D Printer should be equipped with an original transformer or power supply. Otherwise, the machine could be damaged or even cause a fire.Always place the printer on a stable base where it cannot fall of tip over.Please ensure the printer is far away from flammable gas , liquid and dust while it is being operated. (The high temperature generated by the operation of the printer may react with the dust, liquid or flammable gases in the air, which may cause a fire.)The ambient temperature recommended for using the printer is 10 C-30 C, and the humidity 20%-70%. Using the print outside theses ranges may cause poor printing results. Please never expose the printer to moisture or heat. Never use the printer during an electrical storm. The printer is for indoor-use only.If you are not suing the printer for a long time, please turn off the printer and unplug the power cord. Safety Manual 1. When the printer is working, DO NOT TOUCH the heat generating parts,NOT even with gloves, as the extreme heat can melt the gloves causing severe burns. WARNING: THE NOZZLE TIP CAN HEAT TO 260C AND THE PRINT BED CAN HEAT TO 100 C.
2. DO NOT TOUCH any working parts while printer is printing. The nozzle tip and other mechanical parts will run at high speed.
Contact with any running parts may cause damage and injury. 3. When printing with PLA or Wood materials ensure the printer is in a well ventilated environment, due to the fumes released by the plastic materials. 4 .NEVER allow children or untrained people to operate the printer. Daily Maintenance Please do dust removal maintenance and lubricate the printer every month. If you are not using the printer for a long time, please remove the filament and keep the storage environment dry, dust -free. The printer should place in a temperature-stable environment.

The sudden drop in temperature can affect the printing quality. When the print nozzle is squeezing, please make sure there is enough space between the nozzle and the platform; otherwise the nozzle will be blocked. 1.Clean/Maintain the print platform, replace the tape if used. 2.Preheat the nozzle and extrude a small amount of filament. 3.While the nozzle is still hot, use a steel brush on it to clean any excess filament. 4.Preheat the print bed and level it.